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INFORMATION REPORT

COUNTRY USSR (Caucasus)

SUBJECT Tsentrolit Foundry at Tbilisi (Tiflis)

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1. The Tsentrolit Foundry is located several kilometers north of the town of Tbilisi (Tiflis). There is another foundry of the same name in Leningrad. Both are controlled by the Ministry for Manufacture of Machine Tools, USSR. The director of the Tbilisi Tsentrolit is Sikharulidze.
2. The cast iron and steel produced here goes mainly to machine tool factories. A small part of output goes to local enterprises and to agricultural undertakings. The cast iron is of fairly good quality. ~~The rejected material is due~~ mainly to the presence of gas blisters in castings. Measures have been taken against this and in the last year the quantity of rejected material has been considerably reduced.
3. The cast steel is of good quality and some of the castings have even been sent to Moscow machine tool factories. All steel articles are made only from mild carbon steel. Castings of manganese steel are not made.
4. Tsentrolit also produces bed plates for machine tools. The mixture for filling consists of burnt earth (about 90 per cent), a small quantity of sand, and a little crushed clay. Generally "Shch-24" cast iron is used for casting bed plates. Patterns for casting are made of wood, but on a cast iron plate. The joint of the model is made on a vertical axis.
5. In 1947, about 2,800 tons of machine tool cast iron, 120 tons of cast iron for other undertakings, and about 200 tons of cast steel were produced. In the first six months of 1948, production was as follows:

machine tool cast iron	1,600 tons
cast iron for other purposes	70 tons
cast steel	about 110 tons

In September 1948:

machine tool cast iron	about 270 tons
cast iron for other purposes	" 12 tons
cast steel	" 19 tons

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NO CHANGE in Class. ☐

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6. Electrodes for melting of steel are obtained from a Moscow electrodes factory. In September 1948, about 35 tons of electrodes were received.

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7. Machine tool cast iron goes mainly to the Kirov Machine Tool Factory, in Tbilisi, the "Stanok" Machine Tool Factory in Tbilisi, and, in smaller quantities, to other machine tool factories.
8. Bed plates for DiP machine tools are made for the Kirov Machine Tool Factory, Tbilisi. (DiP = Dognat i Peregnat = Overtake and Pass). It takes about 35 hours to produce a bed plate for the DiP machine tool, excluding about seven hours for the drying of the mould, about three hours for the extraction of the mould after the casting, etc. Fifteen hours are spent on preparing the mould for the core, ten hours on the moulding, five hours on the assembling, and about four on the trimming. Casting of cast iron at a temperature of about 1,400 degrees Centigrade takes about one minute.
9. Since 1946, the cleaning of castings has been done hydraulically with high pressure pumps of about 75 atmospheres. Several specialists from the Moscow "Stankolit" Factory visited the foundry in 1946 to give instruction on the use of the hydro-chamber.
10. In 1947, the foundry began to employ on a small scale castings from modified cast iron for the production of machine tool parts (chucks for lathes, carriages, etc.). Modified cast iron of the following marks is used: MSCh-28-48, MSCh-38-60, etc. At the foundry it is thought that soon the casting of bed plates will also be done from modified cast iron. The total quantity of casting from the moulding and casting area is about 3.5 tons per square meter per annum. This is little in comparison with other foundries of this type.

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